

Date: Wednesday, 9/26/2007 2:09:21 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK PANEL
Job Number : 34898	
Estimate Number : 11093	
P.O. Number :	Part Number : D30231
This Issue : 9/26/2007 S.O. No. :	Drawing Number : D3023 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33367	Material :
Written By :	Due Date : 10/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>107.0926</u>	
Comment : Est. C 02.01.23 Revised NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)  
 2024-T3 .032 sheet  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"  
 Batch: 1106272

30 min  
 18/04/2008  
 S.053 06.07  
 #1 325.7  
 B 34898  
 D 30231

PD 08-04-15

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Trace and Cut Out Panel Using DT8621 Jig

PD 08-04-15

2-Drill Using Dt8621

PD 08-04-15

3-Deburr

Form as per dwg 13023

SB 08/04/16

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12 08/04/17 (1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/04/17 (1)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR 08-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:09:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 34898

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23 ①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/04/23 ①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24

Job Completion



MF 08-04-23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

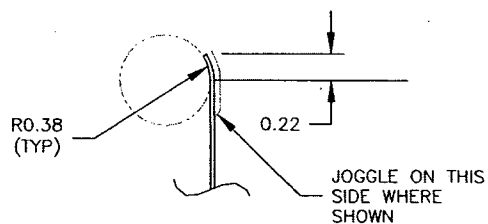
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

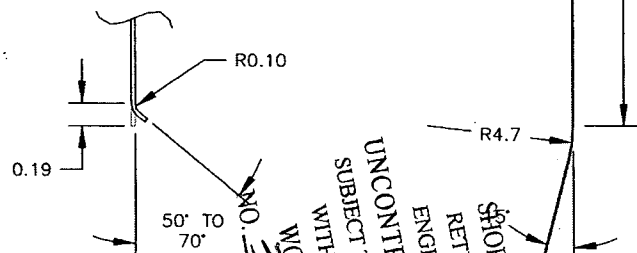
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)



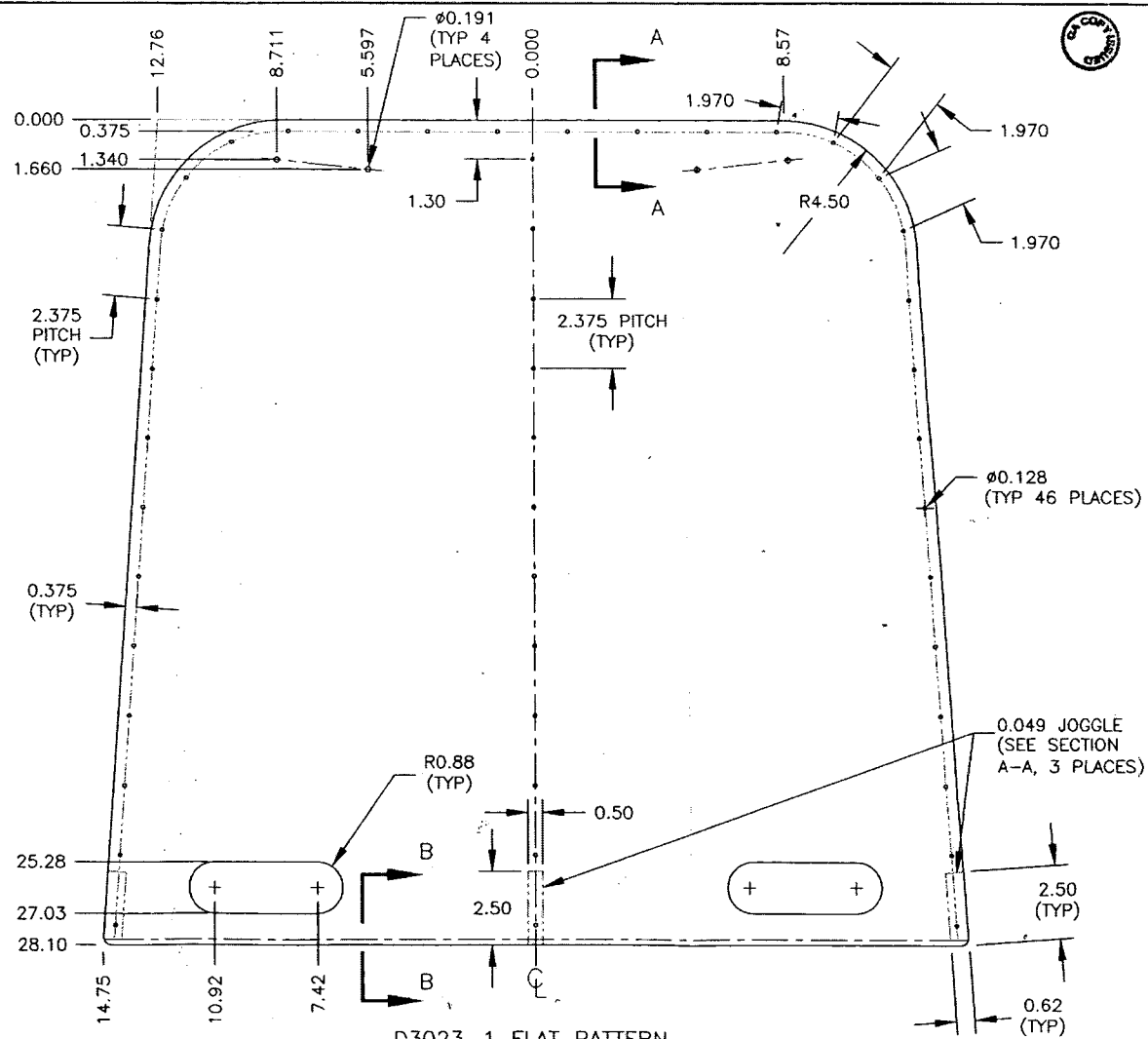
SECTION B-B  
SCALE 1:1  
(BOTTOM EDGE ONLY)



RELEASED  
9.06.07

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SHOP COPY  
NO. 34898  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A		01.05.18	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, OXFORD, CANADA
CHECKED	CP	APPROVED	CP	DRAWING NO. D3023
DATE	01.05.18	TITLE	BACK PANEL	
				REV. A SHEET 1 OF 1 SCALE 1:4